

Date: Wednesday, 2/28/2007 8:21:16 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COWL BRACKET
Job Number	: 30983		
Estimate Number	: 12754		
P.O. Number	: N/A	Part Number	: D2127251119
This Issue	: 2/28/2007	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D212-725-1 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
		Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 3/7/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"

*[Signature]* 07-02-28

Comment: Qty.: 0.2835 f(s)/Unit Total: 1.1340 f(s)

6061-T6 Bar 1.0" x 2.0"

Batch: *M19054*

2.0 BAND SAW BAND SAW

*[Signature]* 07-02-28

Comment: BAND SAW

Cut blank 3.250" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

*[Signature]* 07-02-28

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA674 Rev: *A* & Dwg D121-725-1 Rev: *B*

2-Deburr per dwg D212-725-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]* 07-02-28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

[Signature] 07-02-28

Date: Wednesday, 2/28/2007 8:21:17 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COWL BRACKET

Job Number: 30983

Part Number: D2127251119

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

u JJ 07-02-28 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Cc 7/4/28 (7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Cc 7/4/28 (4)

9.0

QC21

FINAL INSPECTION W/O RELEASE



(4)

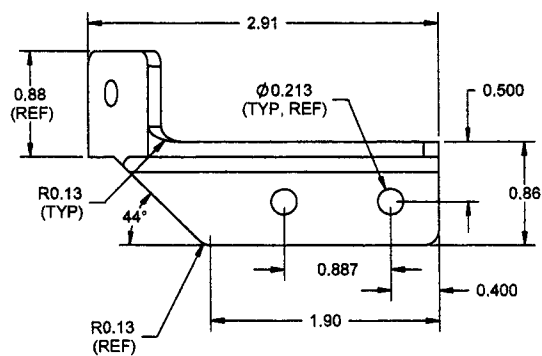
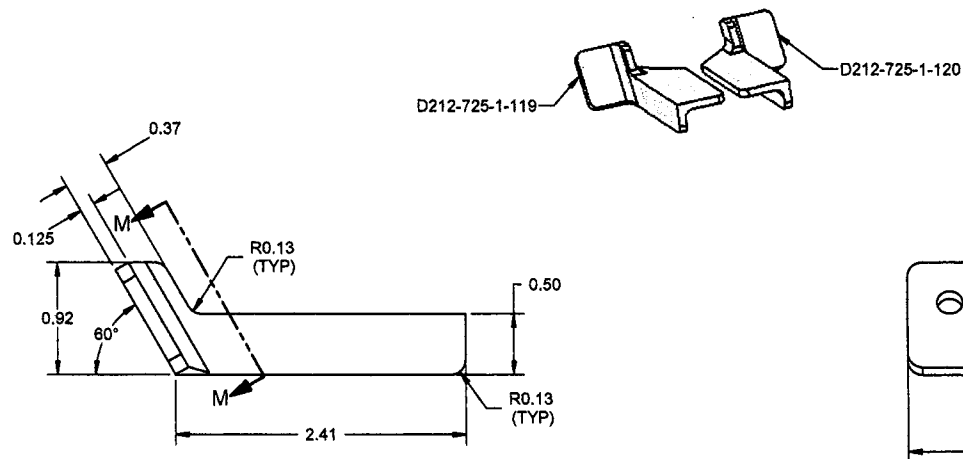
Comment: FINAL INSPECTION W/O RELEASE

07/02/28

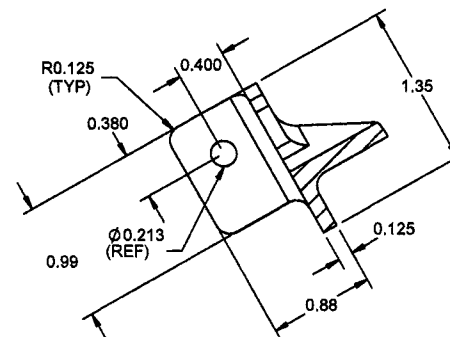
Job Completion



u 07-02-28



**D212-725-1-119 COWL BRACKET, SHOWN
D212-725-1-120 OPPOSITE
(Ø0.213 HOLES TRANSFER FROM AIRCRAFT)**



SECTION M-M

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-225/8) BAR (REF. DART SPEC. M6061T6)
- 2) FINISH: ACID ETCH ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. B SHEET 38 OF 38
DATE 07.01.29		TITLE 212S DETAIL PARTS	SCALE 1:1
COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE LTD		Work Order:
Description: <i>Caul Bracket</i>	Part Number: <i>D212-725-1-119</i>	
Inspection Dwg: <i>D212-725</i> Rev: <i>B</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>.37</i>	<i>+/- .030</i>	<i>.376</i>	<i>-</i>			
<i>.125</i>	<i>+/- .010</i>	<i>.126</i>	<i>-</i>			
<i>.92</i>	<i>+/- .030</i>	<i>.924</i>	<i>-</i>			
<i>.50</i>	<i>+/- .030</i>	<i>.499</i>	<i>-</i>			
<i>R.13</i>	<i>+/- .030</i>	<i>R.125</i>	<i>-</i>			
<i>2.91</i>	<i>+/- .030</i>	<i>2.904</i>	<i>-</i>			
<i>.88</i>	<i>+/- .030</i>	<i>.886</i>	<i>-</i>			
<i>.86</i>	<i>+/- .030</i>	<i>.861</i>	<i>-</i>			
<i>1.61</i>	<i>+/- .030</i>	<i>1.617</i>	<i>✓</i>			
<i>.125</i>	<i>+/- .010</i>	<i>.127</i>	<i>-</i>			
<i>.860</i>	<i>+/- .030</i>	<i>.861</i>	<i>-</i>			
<i>1.35</i>	<i>+/- .030</i>		<i>N/A</i>			
<i>.88</i>	<i>+/- .030</i>	<i>.883</i>	<i>-</i>			
<i>.99</i>	<i>+/- .030</i>	<i>.998</i>	<i>-</i>			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>07.02.28</i>	Date: <i>07.02.28</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	